

Split

# Work Order ID 71743-1

Monday, July 11, 2011 9:00:42 AM



Item ID: D4021-7

Accept



Setup Start



Revision ID:

Item Name: Hoop

Stop



Start Date: 7/11/2011 Start Qty: 6.00



Required Date: 7/15/2011 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 7-11-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

FLOW CNC Waterjet

Qty: 6.00

Memo

0.00

Cut as per dwg D4021

Prog Rev: 1

Dwg Rev: 1

Deburr as required

B11-7-13

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-7-13

# Work Order ID 71743

Monday, July 11, 2011 9:00:42 AM



Page 2

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Start Date: 7/11/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Subst/18



Quality Control

130

0.00



Small Fab

Memo

0.00

Small Fab

1- make radius as per dwg  
2- deburr

GB 4/07/18 7

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subst/18



Quality Control

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Monday, July 11, 2011 9:00:42 AM



Page 3

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Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: WAS

0.00



Packaging

Memo

0.00

Packaging

11-07-20



160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

nh/20  
mf 11-07-20

# Picklist Print

Monday, July 11, 2011 9:00:52 AM

Page 1

Work Order ID: 71743

Parent Item: D4021-7

Parent Item Name: Hoop



Start Date: 7/11/2011

Required Date: 7/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as  
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB  
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.625X3.000

Purchased

No

100

f

1.5500

0.4166

2.631158

3.5



1811-7-13

304 BAR .625 X 3.00

Location

Loc Qty

Loc Code

MAT050

1.55

117130

1.55

117130

8



8

7

6

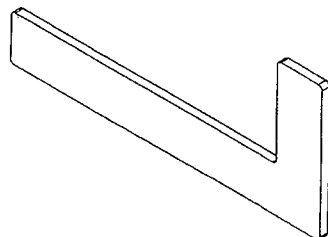
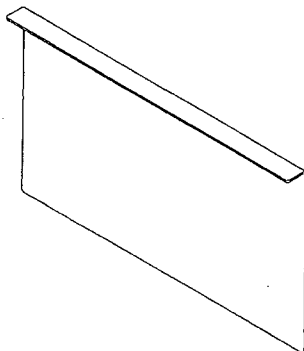
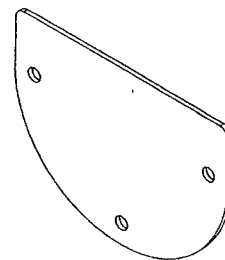
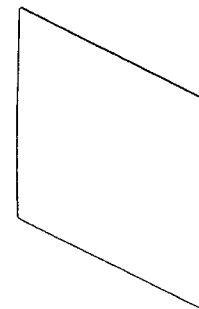
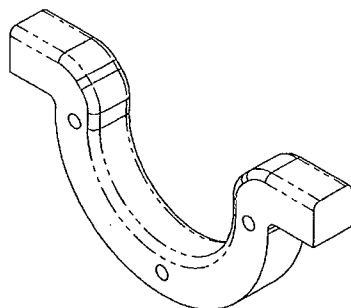
5

4

3

2

1

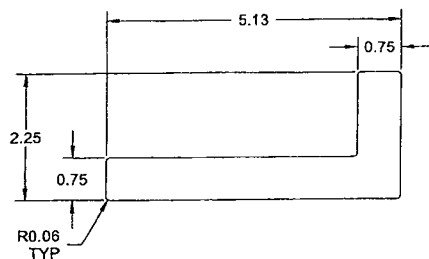
D4021-1 HANDLE PLATED4021-3 DATA PLATED4021-5 BLANKING PLATED4021-11 INSTRUCTIONS PLATED4021-7 HOOPD4021-9 BUSHING

NOT FOR  
RETURN  
ENGINEER  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71243

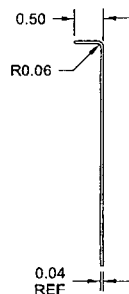
11-07-11

RELEASED  
2010-04-14

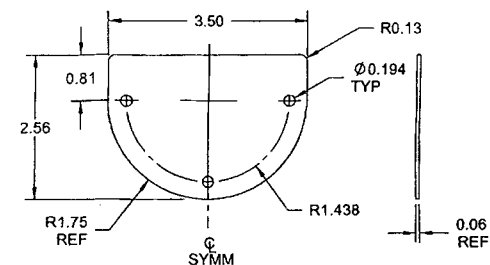
B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



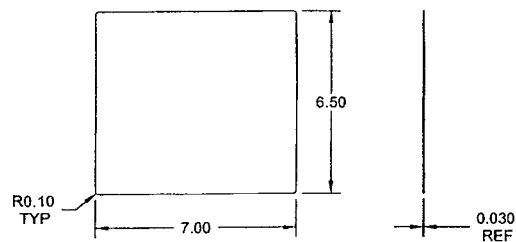
**D4021-1 HANDLE PLATE**



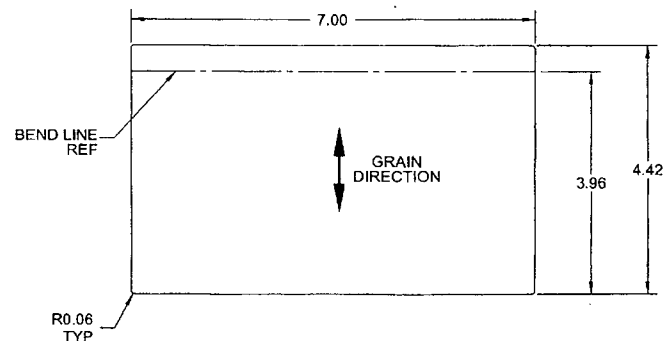
**D4021-3 DATA PLATE**  
MAKE FROM D4021-3F



**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-3F DATA PLATE**  
FLAT PATTERN

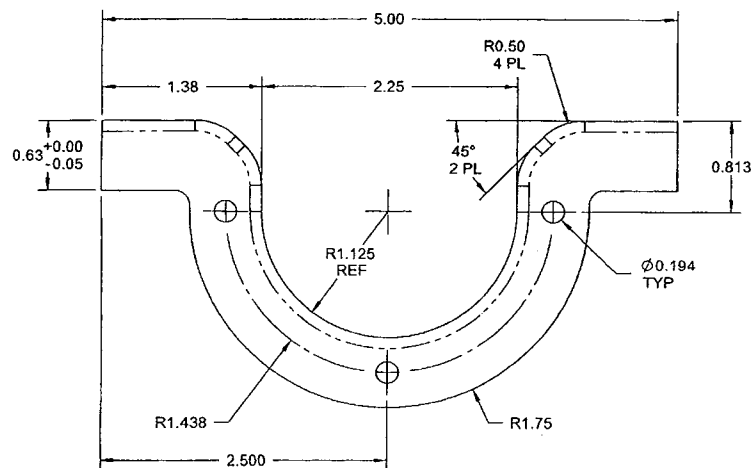
**NOTES:**

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

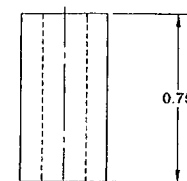
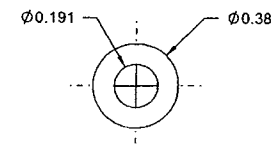
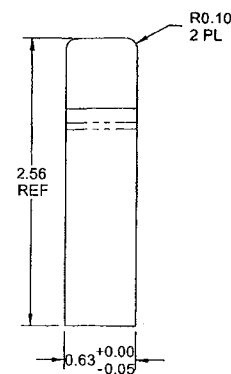
- 2) FINISH: -1/-3/-11: NONE  
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs  
-3: 0.35 lbs  
-5: 0.14 lbs  
-11: 0.39 lbs

**RELEASED**  
R 2010-04-14  
NM

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4021</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>MISC PARTS - 350 BASKET</b>	NTS
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**D4021-7 HOOP**



**D4021-9 BUSHING**

**NOTES:**

1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
REF DART SPEC M304R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT -7: 0.80 lbs

-9: 0.02 lbs

**RELEASED**  
2010-04-14  
NR

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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